

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77019

77019

Page 2

Thursday, November 24, 2011 3:22:16 PM

Item ID: D2858-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 11/24/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 12/5/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00	SL	12-01-04					
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

21X Ø m-l 12/01/05

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									

21X Ø m-l 12/01/10

Memo
 START TIME: 8:30 OVEN TEMPERATURE:
 FINISH TIME: 9:00

3200F

9:00

M119480

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00				21x	4	12/01/10	
Quality Control						COUNT			
170	Identify as per dwg & Stock Location: 19	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/12 [Signature]
 ME
 12-01-12

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Picklist Print

Thursday, November 24, 2011 3:22:20 PM

Page 1

Work Order ID: 77019

77019

Parent Item: D2858-1

D2858-1

Parent Item Name: Hinge Bracket

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			100	f	24.1120	0.163	3.431579			

M6061T6B1 500X01 250

**

6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT004

24.112

118071

0.112

119513

24

3.6 *mk 11/24/24*

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77019
Description: Hinge Bracket		Part Number:	D2858-2
Inspection Dwg: D2858	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	.173	✓		FK-04	Vern.
Ø0.400	+0.005/-0.000	.403	✓		"	"
R0.125	+/-0.010	.125	✓		rad gauge	
0.328	+/-0.010	.327	✓		FK-04	Vern.
0.820	+/-0.005	.820	✓		FK-04	Vern.
1.476	+/-0.010	1.478	✓		"	"
0.342	+/-0.010	.343	✓		"	"
0.875	+/-0.010	.875	✓		"	"
1.56	+/-0.030	1.566	✓		"	"
0.147	+/-0.010	.150	✓		"	"
0.717	+/-0.010	.717	✓		"	"
0.697	+/-0.010	.697	✓		"	"
0.229	+/-0.010	.231	✓		"	"
R0.125	+/-0.010	.125	✓		rad gauge	
R0.063	+/-0.010	.063	✓		"	
0.063	+/-0.010	.065	✓		FK-04	Vern
0.126	+/-0.010	.125	✓		"	"
0.630	+/-0.010	.635	✓		31006	Height gauge
R0.354	+/-0.010	.353	✓		rad gauge	
0.965	+/-0.010	.969	✓		FK-04	Vern.
Ø0.166	+0.005/-0.000	.166	✓		"	"

Measured by: FK	Audited by: JL	Preliminary Approval:
Date: 12/01/04	Date: 12-01-04	Date:

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	
B	11.11.07	Dwg Rev updated	KJ	

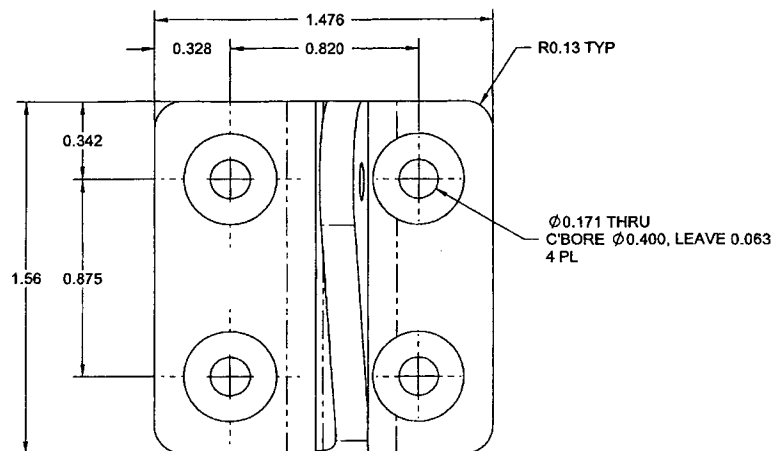
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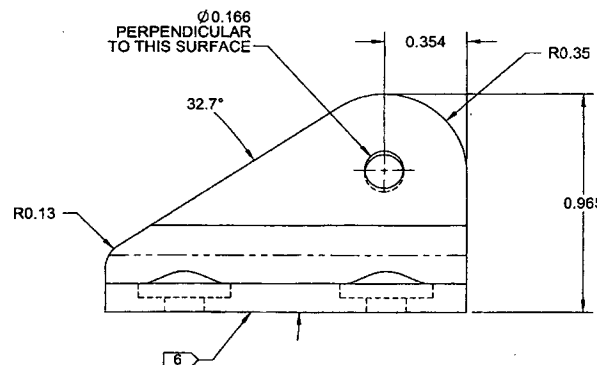
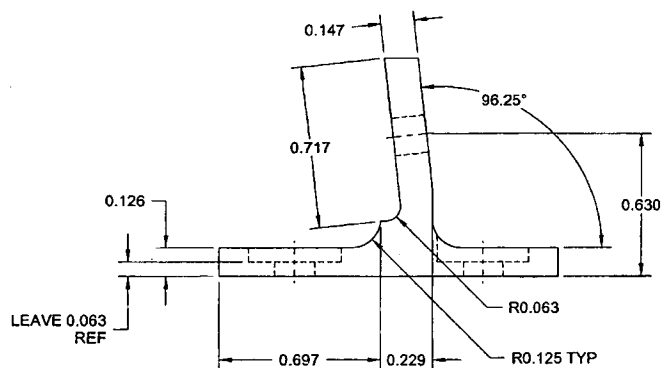
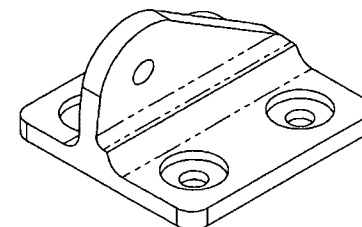
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REF TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
DRAWING NO. 77019
R11-1124



RELEASED
2010-11-26

D2858-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

C	REDRAW TO CURRENT STD. REMOVE ENGRAVED P/N, IDENT. NOW W/ MARKER (A8-1A8-2), REF PAR 10-040	CP	10.10.12
B	0.717 WAS 0.667, 1.56 WAS 1.559	KE	99.02.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2858** REV. C
SHEET 1 OF 2

TITLE **HINGE BRACKET** SCALE
NTS

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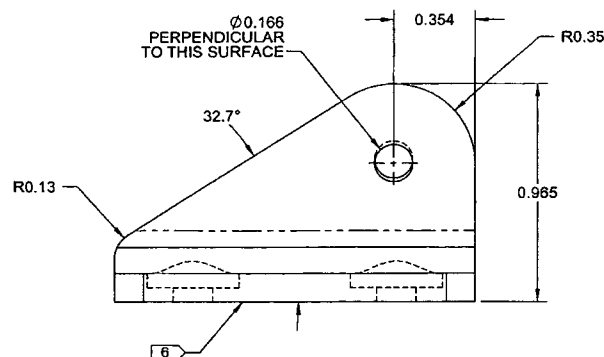
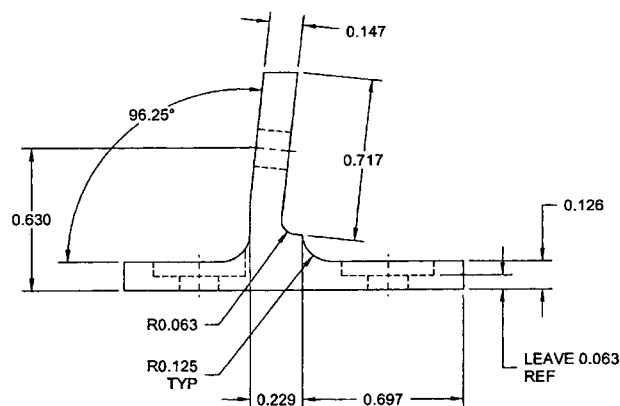
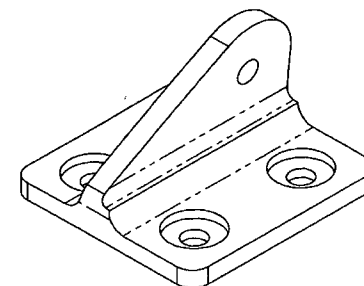
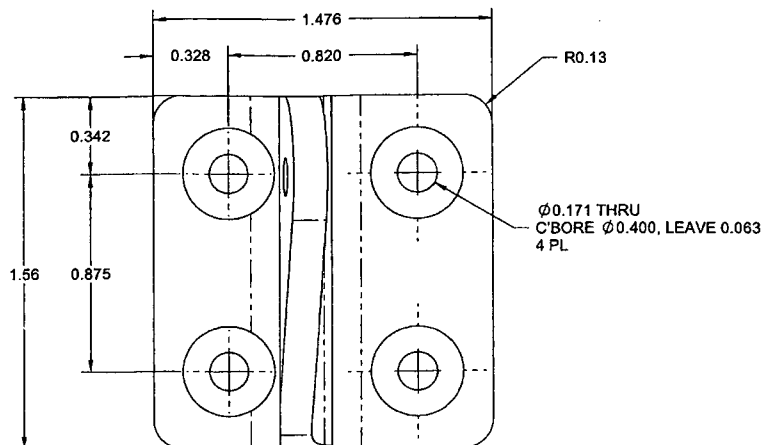
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11019

RELEASED
2010-11-26

D2858-2 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-2" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2858	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE BRACKET	NTS
DATE	10.10.12	COPYRIGHT © 1998 BY DART AEROSPACE LTD	
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